



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C45-12-5

Job Sheet 175725



Part No: C45-12-5

Job Qty: 20 ea

Part Name: Lock Roller Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 4/10/18

Job Tracking No:

Due Date: 5/18/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C45-12-5 REV 2A IPP REV A 18.02.14 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		5/18/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	20 pcs		5/18/18	0.00	2.00	Bandsaw1		
110	Outsource	20 pcs		5/18/18	0.00	0.00	Outsource1		
115	Packaging	20 pcs		5/18/18	0.00	0.00	Packaging2		
118	QC	20 pcs		5/18/18	0.00	0.00	QC6		
120	CNC Lathe	20 pcs		5/18/18	0.50	2.00	MORI SL-154		
130	QC	20 pcs		5/18/18	0.00	0.00	QC2 Machining-5		
140	QC	20 pcs		5/18/18	0.00	0.00	QC8 Machining-5		
142	Outsource	20 pcs		5/18/18	0.00	0.00	Outsource15		
144	Packaging	20 pcs		5/18/18	0.00	0.00	Packaging2		
146	QC	20 pcs		5/18/18	0.00	0.00	QC6		
150	Packaging	20 pcs		5/18/18	0.00	0.00	Packaging3-2		
160	QC21-SA	20 Ea		5/18/18	0.00	0.00	QC21		

Part Op 100 - CUT TO 36.0" ***Send 36.0" bar for heat treating***

Descriptions: 110 - 1-Issue P/O to Metcore ; P/O _____ RC 44-46 2-Bead blast 3- Certificate of Conformity is required
120 - 1-Machine as per folio FC046 FOLIO REV: _____ DWG REV: _____ 2-Deburr ***36.0" makes qty of 24 pcs.***
142 - -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 - Certificate of Conformity is required
150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R0.500	4140 Round Bar 0.500"	60 ft (3 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140H-R0.500	60	108	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C45-12-5
Job Sheet 175725



Folio/501

Part No: C45-12-5

Job Qty: 12 ea

Part Name: Lock Roller Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/19/18 *S-18*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C45-12-5 REV 2A IPP REV A 18.02.14 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		4/18/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	12 pcs		4/18/18	0.00	1.20	Bandsaw1		
110	Outsource	12 pcs		4/18/18	0.00	0.00	Outsource1		
115	Packaging	12 pcs		4/18/18	0.00	0.00	Packaging2		
118	QC	12 pcs		4/18/18	0.00	0.00	QC6		
120	CNC Lathe	12 pcs		4/19/18	0.50	1.20	MORI SL-154		
130	QC	12 pcs		4/19/18	0.00	0.00	QC2 Machining-5		
140	QC	12 pcs		4/19/18	0.00	0.00	QC8 Machining-5		
142	Outsource	12 pcs		4/19/18	0.00	0.00	Outsource15		
144	Packaging	12 pcs		4/19/18	0.00	0.00	Packaging2		
146	QC	12 pcs		4/19/18	0.00	0.00	QC6		
150	Packaging	12 pcs		4/19/18	0.00	0.00	Packaging3-2		
160	QC21-SA	12 Ea		4/19/18	0.00	0.00	QC21		

Part Op 100 - CUT TO 36.0" ***Send 36.0" bar for heat treating***

Descriptions: 110 - 1-Issue P/O to Metcore ; P/O _____ RC 44-46 2-Bead blast 3- Certificate of Conformity is required

120 - 1-Machine as per folio *FE 046* FOLIO REV: _____ DWG REV: _____ 2-Deburr ***36.0" makes qty of 24 pcs.***

142 - 1-Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 - Certificate of Conformity is required

150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R0.500	AISI 4140 Quenched & Tempered Steel Round Bar 0.500" Dia.	1.4280 ft (.119 ea)	90-Start up Operation	
<i>M4140H-R0.500 x 3'</i>				

Job Allocations

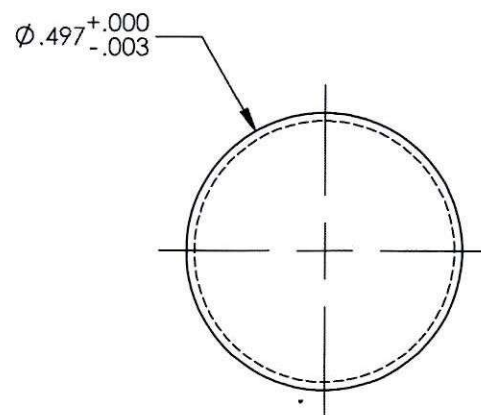
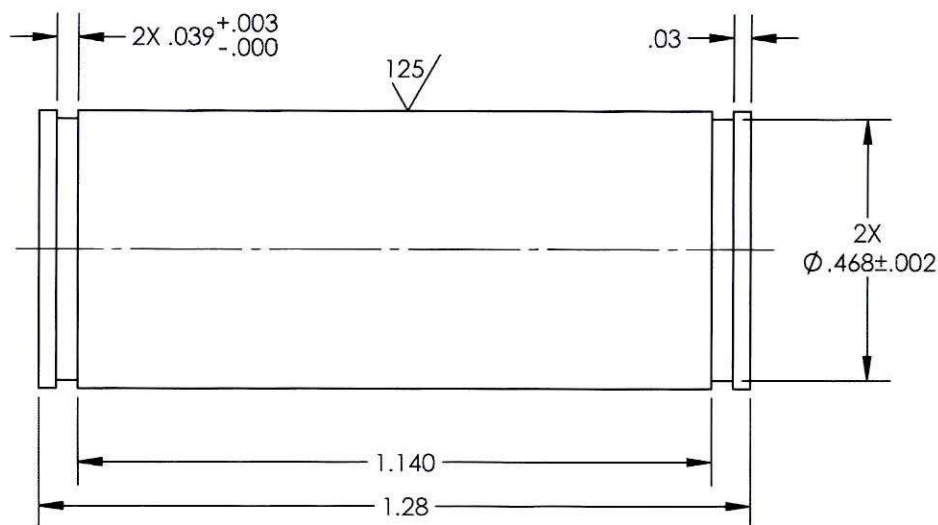
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R0.500	1	10	0

Part Specifications

Specifications could not be found.

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		AS DRAWN BY CANAM.			9/12/2012	RJC	
2		CH'D Ø.465 TO Ø.468 WITH TOL.			10/17/2012	JAG	
2A	14-0127	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. CH'D NOTE 3 WAS AFTER NICKEL PLATING BUFF SURFACE TO 125 IS SURFACE FINISH APPLIES AFTER NICKEL PLATING. CH'D DIM WAS 2X .031 IS .03. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.			8/14/2014	DPD	RW



NOTES:

1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
2. POLISH OD AFTER HEAT TREAT.
3. SURFACE FINISH APPLIES AFTER NICKEL PLATING.
4. BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK ROLLER PIN	
DWG NO. C45-12-5	REV 2A
MAT'L 4140/4142	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D. Weil</i> HEAT TREAT RC 44-46 FINISH SEE NOTE 1
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC USED ON MODEL
SCALE 3:1	DATE 10/28/1998
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-12-5	1	LOCK ROLLER PIN	4140/4142	Ø1/2 X 7/16